

Work Order ID 130432-1

130432

Page 1

March-11-15 9:25:19 AM

Item ID: D3153-12-09

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Panel, Beige

Start Date: 3/11/15 Start Qty: 2.00

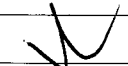
Required Date: 3/31/15 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start *NR1*

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3153

Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

27735

0.00

Purchasing

Issue P/O:

Fabricate D3153-12-09 as per Dwg D3153

Possible Supplier: Delastek

Certificate of Conformity & Process sheet are required



110

Receive & Inspect for Damage & Mat'l Certs

0.00

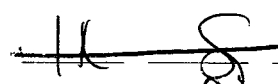
110

Packaging

Memo

0.00

Packaging


1x sel 15/04/21

Work Order ID 130432

130432

Page 2

March-11-15 9:25:19 AM

Item ID: D3153-12-09 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Panel, Beige
 Start Date: 3/11/15 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 3/31/15 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Identify as per dwg & Stock Location: <u>Sold</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									

140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
15-4-21

Picklist Print

March-11-15 9:25:19 AM

Page 1

Work Order ID: 130432

130432

Parent Item: D3153-12-09

D3153-12-09

Parent Item Name: Panel, Beige

Start Date: 3/11/15

Required Date: 3/31/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.07.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3153-12		Manufactured	No				Each	0.0000					
D3153-12 Panels	DAS 46 9-89								**	² SQ 15/04/21			

MKYD61855.125-P3-62015

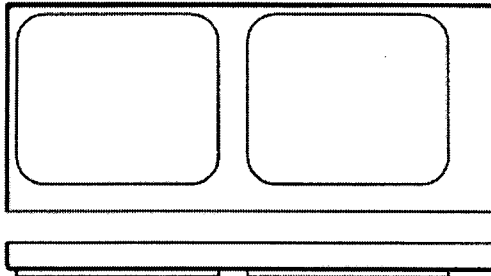
M 127761

705F

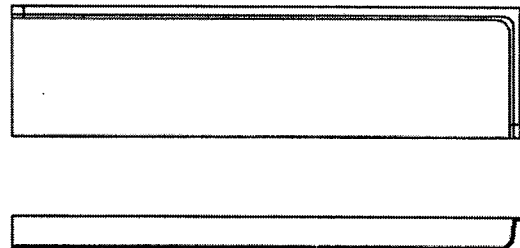
CL 15/04/21

DART

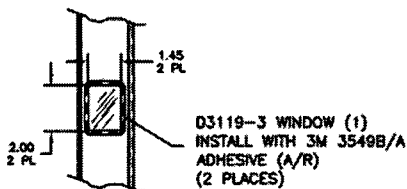
DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3153	REV. B SHEET 1 OF 1
DATE 05.06.09		TITLE PANEL	SCALE NTS
A	02.04.24	NEW ISSUE	
B	05.06.09	D3153-13/-15 VIEW CORRECTION	



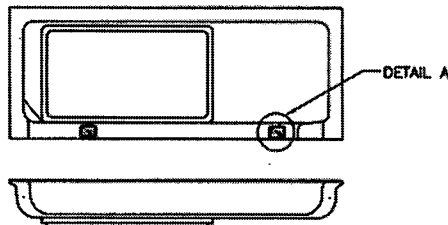
D3153-11-XX PANEL (SHOWN)
D3153-12-XX PANEL (OPPOSITE)



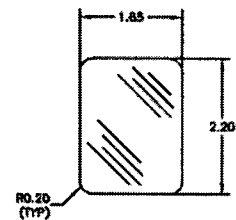
D3153-13-XX PANEL (SHOWN)
D3153-14-XX PANEL (OPPOSITE)



DETAIL A



D3153-15-XX PANEL (SHOWN)
D3153-16-XX PANEL (OPPOSITE)



D3119-3 WINDOW
(FOR REFERENCE)

NOTES:

- 1) MATERIAL: KYDEX 100, 0.093" THICK
- 2) MAKE PARTS PER MOLD; AND REPLACE PREMIER P/N:

P/N	MOLD	REPLACES PREMIER P/N
D3153-11-XX	B56-43000-11T	B56-43000-11
D3153-12-XX	B56-43000-12T	B56-43000-12
D3153-13-XX	B56-43000-13T	B56-43000-13
D3153-14-XX	B56-43000-14T	B56-43000-14
D3153-15-XX	B56-43000-15T	B56-43000-15
D3153-16-XX	B56-43000-16T	B56-43000-16
- 3) COLOR PER CUSTOMER SPECIFICATION (-XX):

DASH No.	PART NO.	COLOR	VENDOR
-01	52000	CALCUTTA BLACK	KYDEX
-03	52001	PENETER GRAY	
-05	52114	BLACK	
-07	62033	MONTEREY	
-09	72005	BEIGE	

EXAMPLE: D3153-11 IN CALCUTTA BLACK KYDEX = D3153-11-01

- 4) D3119-3
MATERIAL: LEXAN, 0.060 THICK

RELEASED
05-06-16

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Linda Lacelle

From: David Shepherd
Sent: March-18-15 12:52 PM
To: Linda Lacelle; Chris Provencal
Subject: RE: D3153 VIP panel

Linda,

Based on how thin those VIP trim panels get when we form them, I think it would be better to try the 0.125" thick sheet rather than the 0.080" thick sheet.

Regards,
David

From: Linda Lacelle
Sent: March-18-15 7:13 AM
To: David Shepherd; Chris Provencal
Subject: RE: D3153 VIP panel

Oh, and the .125 sheet is too damn short!

From: Linda Lacelle
Sent: March-18-15 9:07 AM
To: David Shepherd; Chris Provencal
Subject: FW: D3153 VIP panel
Importance: High

Bill Bury just came to see me, and we only have .080 and .125 in the Kydex 6185 (sigh) The D3153-12 calls up Kydex 100, .093"..
Can we use either of the .080 or .125 for this order??

L

From: Linda Lacelle
Sent: March-18-15 8:09 AM
To: Melody Shapcott (MShapcott@delastek.com)
Cc: 'Jocelyne Laurin' (jlaurin@delastek.com); David Shepherd

Subject: FW: D3153 VIP panel

Importance: High

Melody,

As requested, we authorize Delastek to use Kydex 6185 on our PO27735, for qty 2 x D3153-12. We will supply the material and have it delivered to your facility.

Thank you,

Linda

From: David Shepherd

Sent: March-15-15 11:42 PM

To: Linda Lacelle; Chris Provencal

Cc: Nigel Forbes; Sian Willems

Subject: RE: D3153 VIP panel

Linda,

Agree with Daryl ... I don't see a problem using any of Kydex 6185 materials that we already certified for other products.

Regards,

David

From: Linda Lacelle

Sent: March-13-15 8:36 AM

To: David Shepherd; Chris Provencal

Cc: Nigel Forbes; Sian Willems

Subject: RE: D3153 VIP panel

Or, as Daryl stated, use the Kydex6185. The customer is painting the panels anyway

L

From: Linda Lacelle

Sent: March-13-15 10:28 AM

To: David Shepherd; Chris Provencal

Cc: Nigel Forbes; Sian Willems

Subject: D3153 VIP panel

Importance: High

David/Chris,

BHT requires 2 x D3153-12-09 panels asap, but we received a L/T of mid-May from Delastek. We were thinking of bringing the mold back here and thermoforming them in house. I can't find any Kydex 100 as stated on the drwg, but there is an equivalent, can we use this? If we can, perhaps Delastek can also get it done faster...

Please advise asap

Thx

Linda

From: Dixon, Wade L (SABIC Innovative Plastics) [<mailto:wade.dixon@sabic-ip.com>]

Sent: March-13-15 9:56 AM

To: Linda Lacelle

Subject: RE: help

Linda

No Kydex 100 anywhere but have the Boltaron equivalent (see attached)

Boltaron 4330-3530-019

0.093 48x96

HC Beige

\$195.78 per sheet

Plus freight

Wade

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]

Sent: Friday, March 13, 2015 8:30 AM

To: Dixon, Wade L (SABIC Innovative Plastics)

Subject: help

Importance: High

Hi Wade,

I need a couple of sheets of Kydex 100, .093 – 72005 beige...can you help??

Linda Lacelle

Production manager

DART AEROSPACE

T 1-613-632-5200 Ext: 235

Linda Lacelle

From: Melody Shapcott <MShapcott@delastek.com>
Sent: March-17-15 3:11 PM
To: Linda Lacelle; Jocelyne Laurin
Subject: RE: CONFIRMATION ORDER po27735

Hello Linda,

I have discussed with my production team.

We can use your Kydex 6185 but we need a letter attesting that Dart authorizes us to use this type of Kydex for PO: po27735.

We need this delivered ASAP, if you could deliver it for Friday we'd appreciate.

As soon as we will receive your Kydex than we can start producing it on our side.

Let me know what's your status on your side and a waybill # so we track the Kydex.

Thank you,

Melody Shapcott

Gestionnaire de comptes

DELASTEK Inc.

2699, 5e Avenue, Local 14

Grand-Mère, Québec

G9T 2P7

Tel : 819-533-5788 #235

Fax : 819-533-3494

mshapcott@delastek.com

46.8

B/N

2 sheets
45 x 65

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Devez-vous vraiment imprimer ce courriel ? Pensons à l'environnement ! / Please consider the environment before printing this email

De : Linda Lacelle [<mailto:llacelle@dartaero.com>]

Envoyé : 17 mars 2015 12:00

À : Melody Shapcott; Jocelyne Laurin

Objet : RE: CONFIRMATION ORDER po27735

Importance : Haute

Hello again,

If you cannot provide us with a fast leadtime, we can go pick up the mold at your facility and produce the 2 parts here. Please advise asap, as customer is still waiting for a response.

Linda

From: Linda Lacelle

Sent: March-17-15 8:41 AM

To: 'Melody Shapcott'; 'Jocelyne Laurin'

Subject: RE: CONFIRMATION ORDER po27735

Importance: High

Any news on this please??

From: Linda Lacelle

Sent: March-16-15 8:53 AM

To: 'Melody Shapcott'; Jocelyne Laurin

Subject: RE: CONFIRMATION ORDER po27735

If we can change the material to kydex 6185 (which we have in stk), what is the best date you can do please?

Linda

From: Melody Shapcott [<mailto:MShapcott@delastek.com>]

Sent: March-16-15 8:52 AM

To: Linda Lacelle; Jocelyne Laurin

Subject: RE: CONFIRMATION ORDER po27735

Hello Linda,

For the moment this is our best date, we have to wait on the reception of the raw material.

I will let you know in 4 weeks if we can improve our date.

Thank you,

Melody Shapcott

Gestionnaire de comptes

DELASTEK Inc.

2699, 5e Avenue, Local 14
Grand-Mère, Québec
G9T 2P7
Tel : 819-533-5788 #235
Fax : 819-533-3494
mshapcott@delastek.com

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Devez-vous vraiment imprimer ce courriel ? Pensons à l'environnement ! / Please consider the environment before printing this email

De : Linda Lacelle [<mailto:llacelle@dartaero.com>]

Envoyé : 16 mars 2015 08:48

À : Jocelyne Laurin; Melody Shapcott

Objet : RE: CONFIRMATION ORDER po27735

Importance : Haute

Any update on this please?

From: Linda Lacelle

Sent: March-13-15 8:30 AM

To: 'Jocelyne Laurin'

Cc: Melody Shapcott (MShapcott@delastek.com)

Subject: RE: CONFIRMATION ORDER po27735

Importance: High

Any news on this please???

From: Linda Lacelle

Sent: March-12-15 9:59 AM

To: 'Jocelyne Laurin'

Cc: Melody Shapcott (MShapcott@delastek.com)

Subject: RE: CONFIRMATION ORDER po27735

Importance: High

Thanks Jocelyne, is there any way to improve this lead time? This is the same customer that took the last few panels. Please let me know what you can do.

Thx

Linda

From: Jocelyne Laurin [<mailto:JLaurin@delastek.com>]

Sent: March-11-15 4:44 PM

To: Linda Lacelle

Subject: CONFIRMATION ORDER po27735

Thank you

Jocelyne Laurin

Agente Service à la clientèle

Customer Service Agent

Delastek Inc.

2699, 5^e Avenue, local 14

Grand-Mère, Qc G9T 2P7

819-533-5788, poste 221

jlaurin@delastek.com

De : info@delastek.com [<mailto:info@delastek.com>]

Envoyé : 11 mars 2015 16:42

À : Jocelyne Laurin

Objet : Attached Image

Linda Lacelle

From: David Shepherd
Sent: March-15-15 11:42 PM
To: Linda Lacelle; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: RE: D3153 VIP panel

Linda,

Agree with Daryl ... I don't see a problem using any of Kydex 6185 materials that we already certified for other products.

Regards,
David

From: Linda Lacelle
Sent: March-13-15 8:36 AM
To: David Shepherd; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: RE: D3153 VIP panel

Or, as Daryl stated, use the Kydex6185. The customer is painting the panels anyway

L

From: Linda Lacelle
Sent: March-13-15 10:28 AM
To: David Shepherd; Chris Provencal
Cc: Nigel Forbes; Sian Willems
Subject: D3153 VIP panel
Importance: High

David/Chris,

BHT requires 2 x D3153-12-09 panels asap, but we received a L/T of mid-May from Delastek. We were thinking of bringing the mold back here and thermoforming them in house. I can't find any Kydex 100 as stated on the drwg, but there is an equivalent, can we use this? If we can, perhaps Delastek can also get it done faster...

Please advise asap

Thx

Handwritten signature and date:
12/29/16

Linda

From: Dixon, Wade L (SABIC Innovative Plastics) [<mailto:wade.dixon@sabic-ip.com>]
Sent: March-13-15 9:56 AM
To: Linda Lacelle
Subject: RE: help

Linda

No Kydex 100 anywhere but have the Boltaron equivalent (see attached)

Boltaron 4330-3530-019
0.093 48x96
HC Beige
\$195.78 per sheet
Plus freight

Wade

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Friday, March 13, 2015 8:30 AM
To: Dixon, Wade L (SABIC Innovative Plastics)
Subject: help
Importance: High

Hi Wade,
I need a couple of sheets of Kydex 100, .093 – 72005 beige...can you help??

Linda Lacelle
Production manager

DART AEROSPACE
T 1-613-632-5200 Ext: 235



Surface Textures of KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

TB - 105

Introduction

KYDEX, LLC offers eight different textures ranging from high-gloss smooth to leatherette. Each texture presents its own unique opportunities and challenges. Textures are embossed into the sheet during the extrusion process, so available embossings may be limited based on KYDEX® sheet grade, thickness, or width. Talk with your KYDEX® thermoplastic sheet representative for more details. The following is a summary of each texture.

Standard KYDEX® Sheet Textures



P-1 Haircell

- Best abrasion resistance
- Excellent for high abuse areas
- Can tend to have higher metamerism in highly chromatic colours
- Common texture available for many years



P-3 Velour Matte

- Excellent abrasion resistance
- Easy to control gloss when formed
- Most widely specified texture for aircraft components
- Remains very "matte" if formed properly and most looks like a painted composite panel



P-8 Suede

- Good abrasion resistance but can show marring in light colours
- Excellent for textured female molding
- Great for flat laminations but can "gloss up" when vacuum formed



P-A Smooth

- Polished, high gloss appearance
- Prone to scratching
- Cannot be produced in low smoke formulations



P-C Level Haircell

- Leatherette appearance
- Good scratch resistance
- Common for high abuse areas
- Easy to control gloss level when thermoforming

SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

6685 Low St, Bloomsburg, PA 17815 USA

Phone: 800.325.3133, +1.570.389.5810

Outside the US: +1.570.389.5814

Fax: 800.452.0155, +1.570.387.7786

Email: info@sekisui-spi.com

Technical Service

Phone: 800.682.8758

Fax: +1.570.387.8722

Outside the US: +1.570.387.6997

techservice@sekisui-spi.com

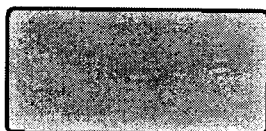
sekisui-spi.com

Surface Textures of KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

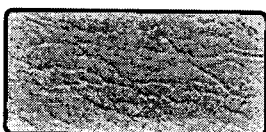
TB - 105

Standard KYDEX® Sheet Textures



P-E Smooth Nap

- Similar characteristics to P-8 Suede texture
- Slightly more embossing compared to P-8 Suede texture



P-H Seville

- Leather/cowhide grain type texture
- Not recommended for deep draw parts due to texture stretch
- Often used against similarly grained leathers



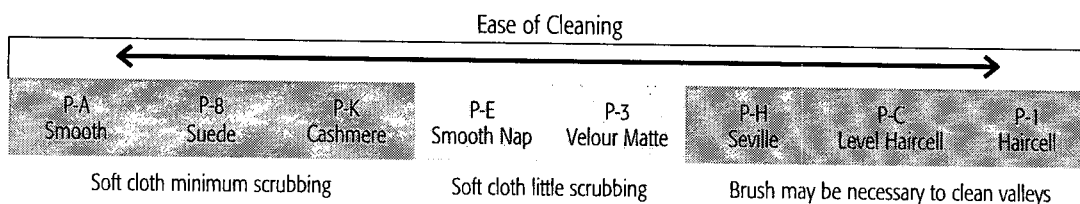
P-K Cashmere

- High abrasion resistance
- Excellent for flat lamination or shallow draw components
- Not recommended for deep draw or tight radii due to glossing

Texture Characteristics

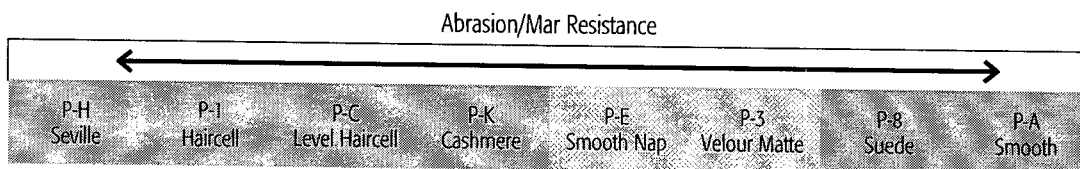
Cleaning

KYDEX® sheet has excellent chemical resistance and is easily cleaned with many common household cleaners such as fantastik® and Formula 409®. The texture of KYDEX® sheet plays a major role in the ease of cleaning. Shallow textured sheet can easily be cleaned with a soft cloth, while a heavier texture may require use of a scrub brush to remove material from texture valleys. For more information on cleaning of KYDEX® sheet, please refer to Technical Brief 160-A - Cleaning KYDEX® Sheet, and Technical Brief 160-B - Cleaning and Maintaining KYDEX® 510, on our website at www.sekisui-spi.com.



Abrasion/Mar Resistance

KYDEX® sheet is commonly used in high abuse applications, where it is important that the appearance of the sheet is maintained throughout the life of the material. Many of the standard textures have been developed to offer high levels of abrasion and mar resistance, providing not only superior durability but also lasting appearance.



SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

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techservice@sekisui-spi.com

sekisui-spi.com

Surface Textures of KYDEX® Thermoplastic Sheet

For information applicable to KYDEX® FST please refer to 300 series technical briefs.

TB - 105

Texture Characteristics

Tooling Marks

Texture rolls are produced through an engraving process that uses a machining tool to cut the texture into the face of a cylinder roll. This tool has a specific width, which machines multiple sections across the width of the cylinder roll. Points on the engraved cylinder where the tooling sections meet have a faint transition line. These lines leave a faint impression in the sheet surface and are more noticeable in darker coloured sheet. Textures that have tooling marks include P-1 Haircell, P-8 Suede, P-C Level Haircell, P-E Smooth Nap, and P-H Seville. P-3 Velour Matte, P-K Cashmere and P-A Smooth are non-directional patterns that do not show tooling marks from the engraving process.

Gloss Level

The gloss level of KYDEX® sheet is determined by the process rolls used to texture the sheet. Most texturing rolls produce a low gloss appearance, with the exception of P-A Smooth, which has a higher gloss due to its polished surface. If necessary, a higher gloss can be achieved by adjusting the process conditions of the texturing rolls in all textures except P-H Seville. The level of gloss achievable will be limited according to the process capabilities of each texturing roll. In addition, in achieving a higher gloss level, the texture of the sheet will be less defined and will have a washed out appearance.

SEKISUI SPI

ISO 9001 and 14001 Certified

Customer Service

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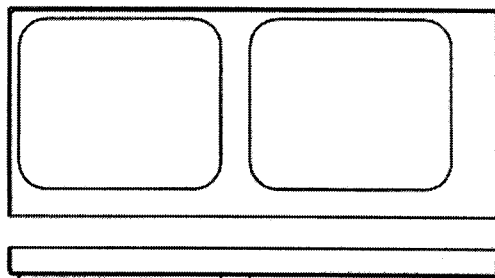
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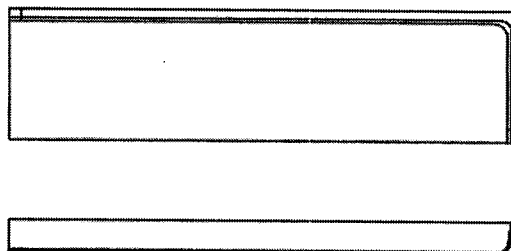
This information supersedes all previously published data.



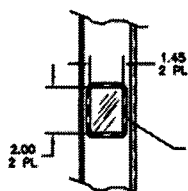
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3153	REV. B SHEET 1 OF 1
DATE 05.06.09		TITLE PANEL	SCALE NTS
A	02.04.24	NEW ISSUE	
B	05.06.09	D3153-13/-15 VIEW CORRECTION	



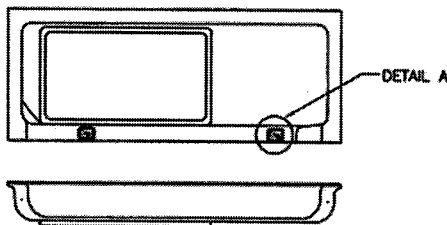
D3153-11-XX PANEL (SHOWN)
D3153-12-XX PANEL (OPPOSITE)



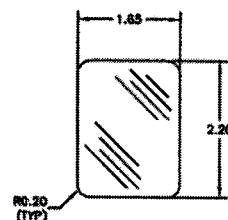
D3153-13-XX PANEL (SHOWN)
D3153-14-XX PANEL (OPPOSITE)



D3119-3 WINDOW (1)
INSTALL WITH 3M 3549B/A
ADHESIVE (A/R)
(2 PLACES)



D3153-15-XX PANEL (SHOWN)
D3153-16-XX PANEL (OPPOSITE)



D3119-3 WINDOW
(FOR REFERENCE)

NOTES:

- MATERIAL: KYDEX 100, 0.093" THICK
- MAKE PARTS PER MOLD; AND REPLACE PREMIER P/N:

P/N	MOLD	REPLACES PREMIER P/N
D3153-11-XX	B56-43000-11T	B56-43000-11
D3153-12-XX	B56-43000-12T	B56-43000-12
D3153-13-XX	B56-43000-13T	B56-43000-13
D3153-14-XX	B56-43000-14T	B56-43000-14
D3153-15-XX	B56-43000-15T	B56-43000-15
D3153-16-XX	B56-43000-16T	B56-43000-16
- COLOR PER CUSTOMER SPECIFICATION (-XX):

DASH No.	PART NO.	COLOR	VENDOR
-01	52000	CALCUTTA BLACK	KYDEX
-03	52001	PENWER GRAY	
-05	52114	BLACK	
-07	62033	MONTEREY	
-09	72005	BEIGE	

EXAMPLE: D3153-11 IN CALCUTTA BLACK KYDEX = D3153-11-01

- D3119-3
MATERIAL: LEXAN, 0.060 THICK

RELEASED
05-06-16

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Linda Lacelle

From: Dixon, Wade L (SABIC Innovative Plastics) <wade.dixon@sabic-ip.com>
Sent: March-13-15 9:56 AM
To: Linda Lacelle
Subject: RE: help
Attachments: Aircraft-Reference-Chart.pdf

Linda

No Kydex 100 anywhere but have the Boltaron equivalent (see attached)

Boltaron 4330-3530-019
0.093 48x96
HC Beige
\$195.78 per sheet
Plus freight

Wade

From: Linda Lacelle [<mailto:llacelle@dartaero.com>]
Sent: Friday, March 13, 2015 8:30 AM
To: Dixon, Wade L (SABIC Innovative Plastics)
Subject: help
Importance: High

Hi Wade,
I need a couple of sheets of Kydex 100, .093 – 72005 beige...can you help??

Linda Lacelle
Production manager

DART AEROSPACE
T 1-613-632-5200 Ext: 235



Boltaron-Kydex Aircraft Cross Reference Chart

COMPETITIVE PRODUCT CROSS REFERENCE

BOLTARON	KYDEX
Boltaron 4205	Kydex 6185
Boltaron 4330	Kydex 100
Boltaron 4330M	Kydex 110
Boltaron 4800	Kydex 6200
Boltaron 6530	Kydex 430
Boltaron 6540	Kydex 430
Boltaron 9200/9200C	Kydex 6185
Boltaron 9230/9230C	Kydex 6185
Boltaron 9250/9250C	Kydex 6185
Boltaron 9815	Kydex 6565
Boltaron 9815D	Kydex 6565D
Boltaron 9815E	Kydex 6565
Boltaron 9815F	Kydex 6565
Boltaron 9815M	Kydex 6565D
Boltaron 9815P	Kydex 6565
Boltaron 9915FSTH	Kydex FST

BOLTARON

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